

Date: Wednesday, 15/04/2009 9:46:42 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT	
Job Number	: 47180		Part Number	: D2565405	
Estimate Number	: 10985		Drawing Number	: D2565 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 15/04/2009	S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	Due Date	: 20/04/2009	
Previous Run	: 37607		Qty:	6 Um: Each	
Written By	:				
Checked & Approved By	: JJD 09.04.15				
Comment	: Est:A 04.05.10 New Issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.7937 f(s)/Unit Total : 10.7623 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	SB 09/04/27 Batch No: M 108498 ① n111096 ① M 111331 ④
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313	SB 09/04/27
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to Ø0.316" as per Dwg D2565 (one end only) Deburr	M 11 09/04/27
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	S 09/04/28 x6
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	m109996
	START TIME: OVEN TEMPERATURE: FINISH TIME:	15:40 400° 16:10	x6 MD/BK 09/04/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST259

SS 09/04/29 K6

8.0 QC21 FINAL INSPECTION/W/O RELEASE



09/04/30 KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

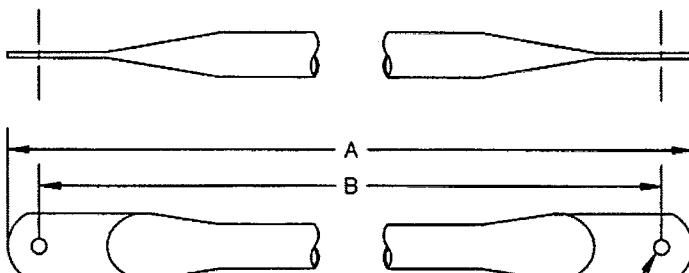
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
 04.05.05

 DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 SUBJECT TO AMENDMENT
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDERNO. 47180

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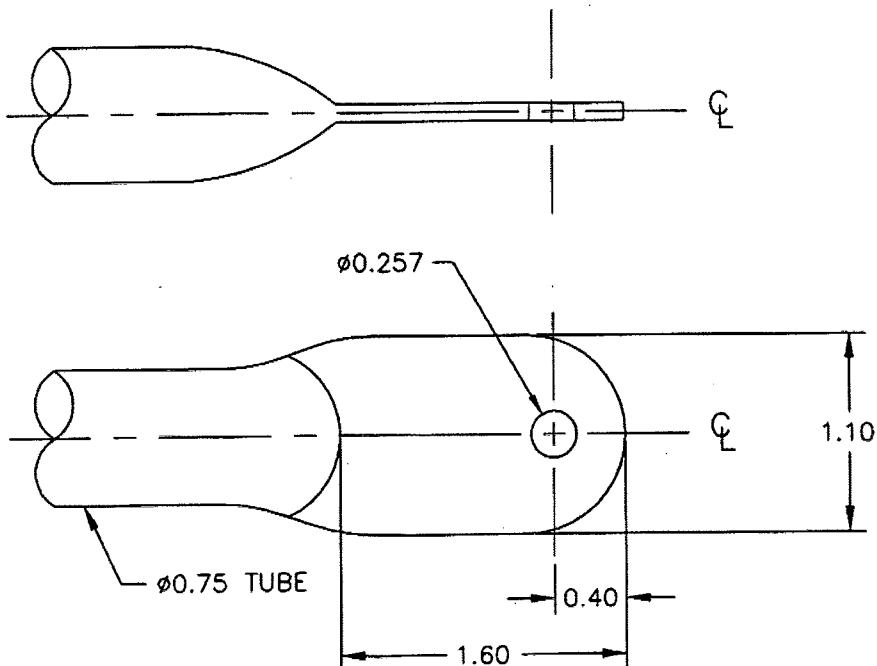
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DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MJ</i>	APPROVED <i>J</i>	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28	TITLE PUNCH DT8117 SPEC CONTROL		SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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